

Work Order ID 81491

March-14-12 4:22:25 PM

ASAP

81491

Page 1

Item ID: D3290-041

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Replacement Window Assembly

Start Date: 14/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan: M25

Date: 12/03/14

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3290

Rev C

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3290 (use prog. for D3290-1)

6061 .063

Dwg Rev: E

Prog Rev: L

2-Deburr if necessary

B12-3-26

8

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

B12-3-26

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

5/12/13/27

x8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 81491

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Page 2

March-14-12 4:22:25 PM

Item ID: D3290-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Replacement Window Assembly
 Start Date: 14/03/2012 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 23/03/2012 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							8X4/M-1 12/03/28
140 *140* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo START TIME: 12/50 OVEN TEMPERATURE: 320°F FINISH TIME: 1h20	0.00 0.00		m120 222					8 2P 12/03/28 2/23/28
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							8 12 12328

W/O:		WORK ORDER CHANGES					
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Revision ID:

Stop ***NS2***

Item Name: Replacement Window Assembly

Start Date: 14/03/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 23/03/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

160

Small Fab

Small Fab

Memo

0.00

0.00

Small Fab

Assemble as per Dwg D3290
Clean D3290-041 and place in plastic wrap

8 SAD 12-04-25

170

170

QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8/24/25

88

180

180

Packaging

Packaging

Identify as per dwg & Stock Location: 218

Memo

0.00

0.00

12/4/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

81491

March-14-12 4:22:25 PM

N900040100

Setup Start ***NS1***

Stop ***NS2***

6

6

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

190

QC

Memo

0.00

Quality Control

12/4/30 ~~9~~

11204-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

March-14-12 4:22:29 PM

Page 1

Work Order ID: 81491

81491

Parent Item: D3290-041

D3290-041

Parent Item Name: Replacement Window Assembly

Start Date: 14/03/2012

Required Date: 23/03/2012

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP B05.05.25Added Step 11KJ/JLM

IPP C06.05.09Ecn 798 EC

IPP Rev:D Now on Waterjet 06-06-16 JLM

IPP rev E rev C dwg 07.09.28 EC verified by: DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased		No		100	sf	416.9996	3.75	23.68421	32		
M6061T6S 063									**	B12-3-2			
6061-T6 .063 Sheet													

Location	Loc Qty	Loc Code
MAT021	416.9995684	
113608	0	
116308	6.51556842	
117285	70.544	
119331	48	
119802	20.94	
120218	31	
120866	240	

D2126

Manufactured No

160 f 465.6608 6.5 39

D2126

Seal

**

SAD 12-04-25

Location	Loc Qty	Loc Code
ST405	465.66079	
57106	4	
68336	26.66079	
76094	435	

(D2126-0780) cut qty (1) at 78.00" as per dwg
per kit

32

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Page 2

March-14-12 4:22:29 PM

Work Order ID: 81491

81491

Parent Item: D3290-041

D3290-041

Parent Item Name: Replacement Window Assembly

Start Date: 14/03/2012

Required Date: 23/03/2012

Start Qty: 6.00

Required Qty: 6.00

D3290-3

Manufactured No

160

Each

7.0000

1

6

D3290-3

Window

**

SAO 12-04-25

Location

Loc Qty

Loc Code

ST221

7

75052

7

B81498

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	81491
Description: Window Frame		Part Number:	D3290-1
Inspection Dwg: D3290 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ **First Article**
☐ **Prototype**

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
29.00	+/-0.030	29.00	2		T B01	
14.00	+/-0.030	14.00	2		T	
Ø0.171	+0.005/-0.001	.174	2		V B02	
1.50	+/-0.030	1.512	2		V	
1.11	+/-0.030	1.111	2		V	
10.10	+/-0.030	10.10	1		T	
18.50	+/-0.030	18.50	2		T	
0.063	+/-0.010	.062	2		V	
R3.00	+/-0.030	3.00	2		R.G	
R4.50	+/-0.030	4.50	2		R.G	
Ø0.257	+0.006/-0.001	.258	2		V	
13.61	+/-0.030	13.61	2		T	

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	12-3-26	Date:	12/03/27	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue P/O D3290-041	KJ/JLM	
B	07.07.18	13.61 dimension removed	KJ/JLM	
C	07.09.28	Dimensions update per Dwg Rev C	KJ/EC/DD	
D	09.11.04	Dimension 0.063 was 0.040	KJ	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

FWD
INBOARD

D2126-0780 LOCKING SEAL
(TRIM TO FIT)
D3290-1 WINDOW FRAME
D3290-3 WINDOW

1.10 (TYP)
DIST. FROM FRAME
EDGE TO WINDOW

D2126-0780 LOCKING SEAL
(REF)

ENSURE D3290-3 WINDOW IS INSTALLED
ON CORRECT SIDE OF D3290-1 WINDOW FRAME

SECTION A-A
NTS

D3290-041 REPLACEMENT WINDOW ASSEMBLY

D3290-041 NOTES:
1) WEIGHT: 3.66 LBS

GENERAL NOTES:

- 1) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) UNITS: INCHES UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 81491 MLCJ

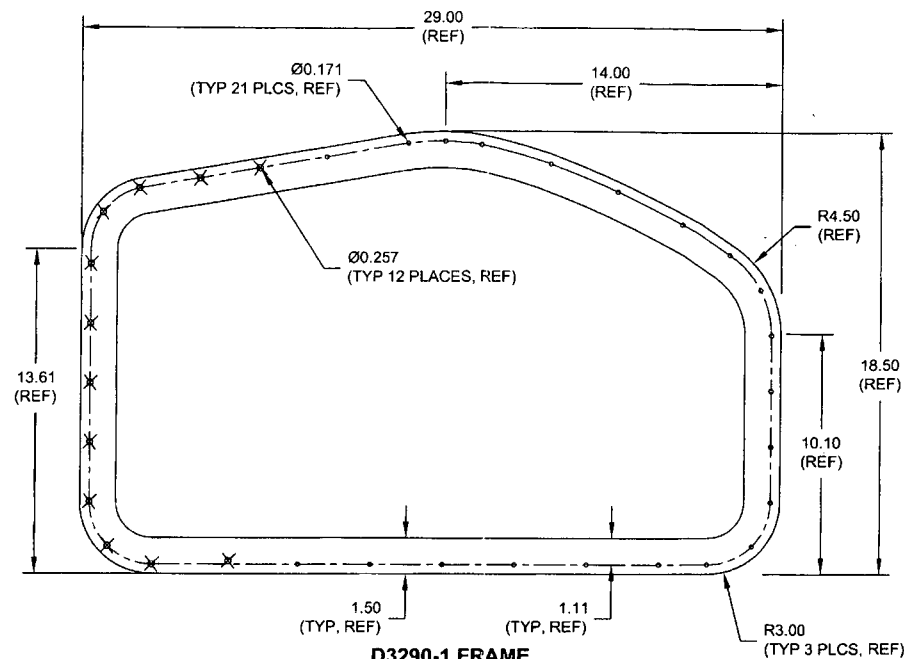
12/03/14

UNDER REVIEW

4/09.01.18

7/12 09-03-7

6/9/10/19



D3290-1 FRAME

D3290-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.040)
OR
5052-H32 ALUMINUM SHEET 0.040 THICK
PER AMS-QQ-A-250/8 OR AMS 4016
(REF. DART SPEC. M5052H32S.040)
- 2) FINISH: CHEMICAL CONVERSION COAT PER QSI 005 4.1
POWDER COAT WHITE (REF. 4.5.3.1) PER DART QSI 005 4.3
- 3) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N "D3290-1" USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.47 LBS

RELEASED
07.07.24

DEO ATTACHED

C	UPDATE DIMS PER PAR 188	DC	07.07.24
B	UPDATE MATERIAL PER NCR 029	MB	06.04.20
A	NEW ISSUE	RF	04.06.14
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.07.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3290
REV. C
SHEET 1 OF 2

TITLE
REPLACEMENT WINDOW ASSEMBLY
SCALE
1:5

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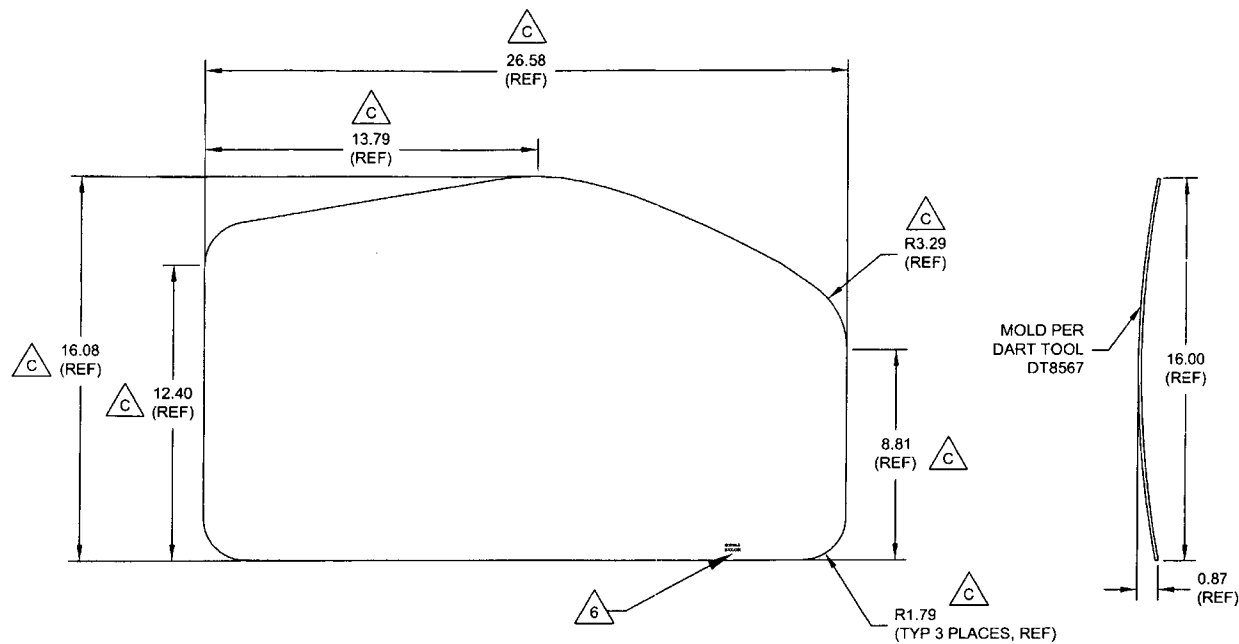
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries









D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

UNDER REVIEW
07.07.24

DEO ATTACHED
RELEASED
07.07.24

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD	
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DRAWING NO. D3290	TITLE REPLACEMENT WINDOW ASSEMBLY	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3290-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>q</i>	CHECKED <i>b</i>	MFG. APPR. <i>E</i>	APPROVED <i>MD</i>		DE APPR. <i>#</i>		
DATE 09.09.18	DATE 09.09.18	DATE 09.09.18	DATE 09/09/21		DATE 09/09/21		

PURPOSE:

CHANGE MATERIAL THICKNESS OF D3290-1 FRAME TO 0.063 FROM 0.040. REF PAR 09-033.

CHANGE:

MATERIAL CALL-OUT OF D3290-1 FRAME ON SHEET 1 IS AMENDED AS FOLLOWS:

81491

D3290-1 NOTES

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
~~(REF. DART SPEC. M6061T6S.040)~~ REF. DART SPEC. M6061T6S.063 (REPLACE)
 OR
 5052-H32 ALUMINUM SHEET ~~0.040 THICK~~ 0.063 THICK (REPLACE)
 PER AMS-QQ-A-250/8 OR AMS 4016
~~(REF. DART SPEC. M5052H32S.040)~~ REF. DART SPEC. M5052H32S.063 (REPLACE)

RELEASED
 2009 -10- 09
MD

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